

D266-628034

Dart Aerospace Ltd.

Date: Thursday, 2/22/2007 2:57:07 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY LH (206/407)  
 Job Number : 30807A  
 Estimate Number : 11775  
 P.O. Number : N/A Part Number : D2842042  
 This Issue : 2/22/2007 S.O. No. : N/A Drawing Number : D2842 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 29740A Material : N/A  
 Due Date : 3/15/2007 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : 07.02.23  
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B29607

Check Material for any Dents or Defects

FF 07-03-14 2

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

FF 07-03-14 2

PE 07-03-14 2

PE 07-03-14 2

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B29340

PE 07-03-14 2

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

plate

Batch:

B30909-4

PE 07-03-14 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30807A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

plate

Batch: B30668

*PE. 07.03.14 2*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R

AL Rod

Batch: M100237

M100225

*PE. 07.03.19 2*

2-Grind end cap weld flush

*PE. 07.03.19 2*

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*07/03/22 (2)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*221*

*07-03-22 (2)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FF 07/03/22 2*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R

AL Rod

Batch: M100237

*PE. 07.03.22 2*

2-Grind end cap weld flush.

*FF 07/03/22 2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/23 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/23 (2)

13.0

POWDER COATING

POWDER COATING



M103706



(2x)

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m-h 07/03/23

14.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M102974

m-h 07/03/24

15.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19522

16.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M103641

17.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M103691

m-h 07/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M1103480

M-R

07/03/24

19.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

PC 7/3/27 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP D206628034

CU

B 30807

07/03/27 S9

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

P0703108

Job Completion



U 07/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

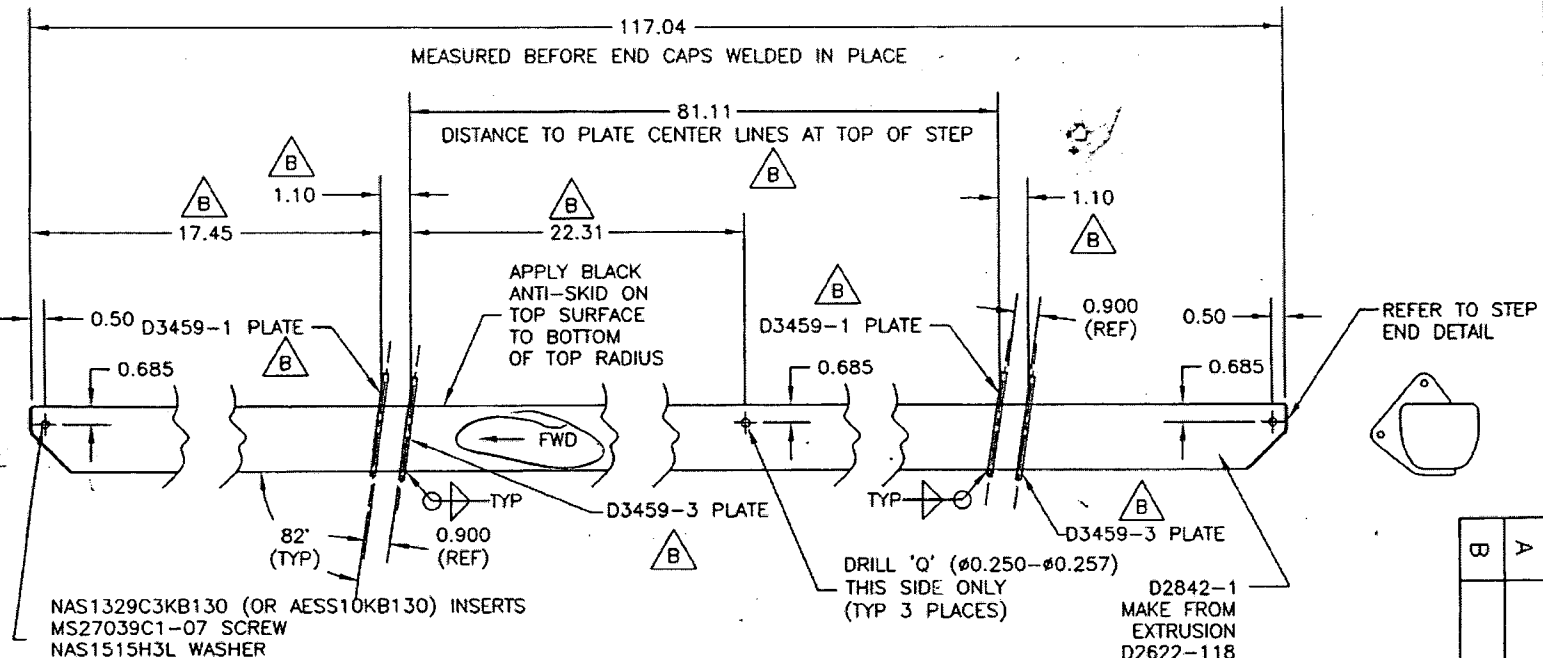
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE		D2842
05.09.23	98.10.13	TITLE
		206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE
		REV. B
		SHEET 1 OF 1



D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
-2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
WITH NOTICE  
NO. 20807A

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
5.1.14

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